

CHAMFERRING THE BORES

1. In order not to cut the o-rings during installation of the new servos, the machined bores need to have a slight additional chamfer put on them. Take your counter sink tool and put a liberal amount of transmission jell or Sil-Glyde on it. This is to help catch the aluminum that will come off during this step. **Note:** This can be done by hand but if you have a small right angle air ratchet or drill you can use that also. Turn the tool by hand in the bore with reasonable pressure until you get about a .030 - .060 chamfer on the bore.



2. Remove the tool and check the bore with your little finger and try to remove any residual chips. You can plug the bore with your finger and blow out the rest of the cavity.